

No material

Dart Aerospace Ltd.

*Date: Friday, 18/07/2008 1:09:59 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 40639		
Estimate Number	: 11162		
P.O. Number	:	Part Number	: D32641
This Issue	: 18/07/2008 S.O. No. :	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40255	Material	:
Written By	:	Due Date	: 10/08/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08.7.18</u>		
Comment	: Est A04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25 X 4.50
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Comment: Qty.: 0.5097 f(s)/Unit Total : 6.1160 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B1.250x04.500)
 Identify for D3264-1
 Batch: M108855

J.L 08/08/23

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

J.L 08/08/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA447 and Dwg D3264
 Identify as D3264-1
 Deburr

J.L 08/08/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/08/24

5.0	QC8.	SECOND CHECK
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Comment: SECOND CHECK

S.P 08/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:09:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40639

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD

08-08-25 X12

7.0

POWDER COATING

POWDER COATING



M108523



(X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40
320°
12:10

M. 08/08/25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-25

(X12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 169

8/8/26

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40639
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.686	✓			
0.063	+/-0.010	.060	✓			
0.125	+/-0.010	.122	✓			
0.875	+0.010/-0.020	.870	✓			
0.062	+/-0.010	.062	✓			
R0.03	+/-0.030	.030	✓			
R0.13	+/-0.030	.130	✓			
1.00	+/-0.030	.999	✓			
0.125	+/-0.010	.123	✓			
0.600	+/-0.010	.600	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	.749	✓			
Ø0.194	+0.005/-0.000	.194	✓			
5.50	+/-0.030	5.499	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.063	✓			
R0.25	+/-0.030	.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	.300	✓			

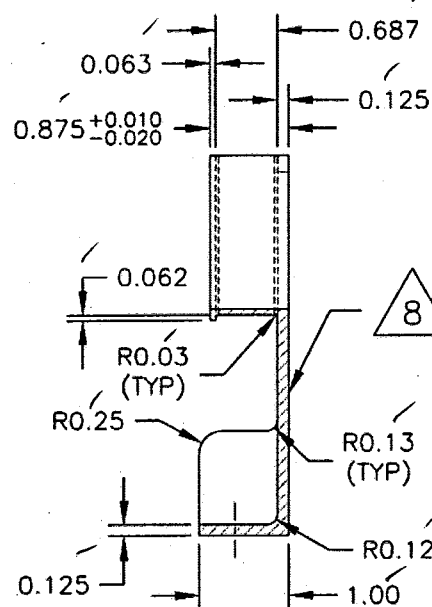
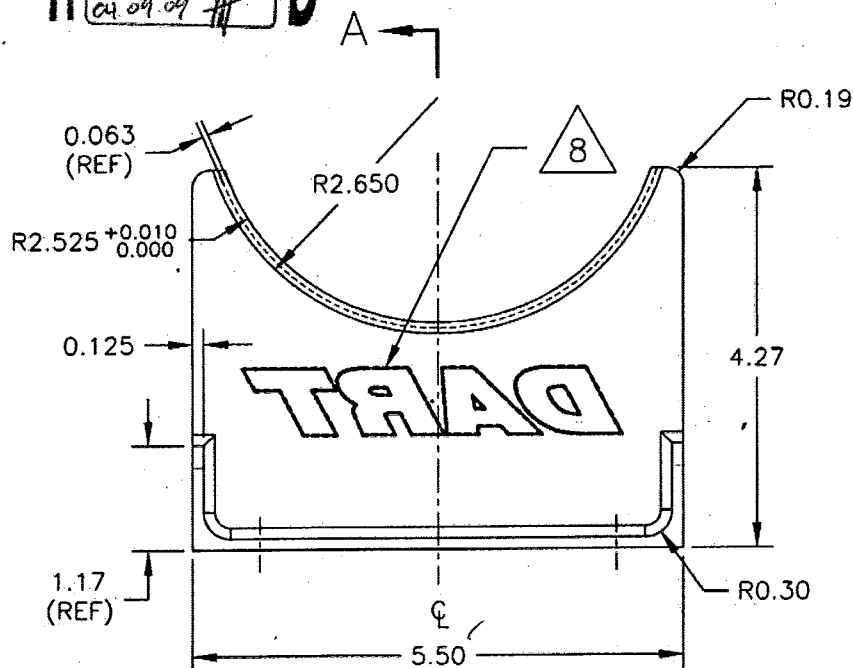
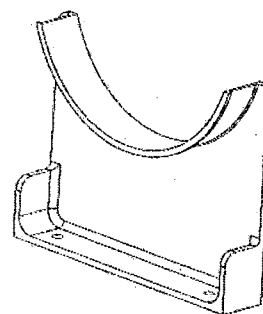
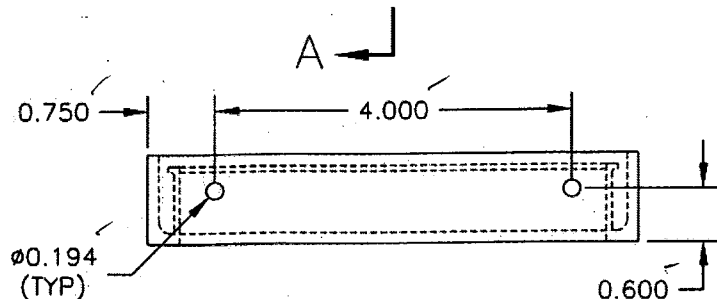
Measured by: J.L.	Audited by: J.P.	Prototype Approval:	N/A
Date: 08/08/24	Date: 08/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 *[Signature]*

**SECTION A-A****D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40059

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